

PROJECT TITLE : SPECIFICATIONS / PROCESS ASSURANCE

Period Covered : 28.1. - 3.3. 1981

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O. SPECIFICATIONS - OVERALL

1. SPECIFICATIONS PER PRODUCTION CENTER PME

1.1 FTR Neuchâtel

1.1.1 Processing:

Expanded tobacco has been introduced in several blends, as follows:

Blend	Previous ESTHER %	N E W ESTHER %	ETNA %	Cigarettes concerned
ML 022 46	7,3	5,7	2,2	MLF MLH MLK MLB MFM
MG 001 52	10,0	8,0	3,0	MER MEM
BR 001 02	7,3	5,3	2,0	ALF BRC BRF
NP 002 40	7,3	5,3	2,0	NPF
BS 007 45	2,7	2,7	2,2	BSB
PM 009 47	7,3	5,3	2,2	PMM
PM 008 48	7,3	5,3	2,2	PMK CRF CRM

1.1.2 Filter Making:

The two filters 34.1205 (BOP 0975 paper) and 34.1200 (24 L paper) have been cancelled. The 40 L filter 34.1210 is now used on all Marlboro cigarettes (dilution 13 % PME).

1.1.3 Cigarette Making:

The tobacco weights of four brands has been adapted so as to comply with the Swiss taxation limits.

The cigarette makers in Neuchâtel are being converted to produce King Size cigarettes with a total length of 84,0 instead of 84,4 mm. The first specs have been adapted.

1.1.4 Packing:

Product version MAA 052 Ambassador, for sale to Konsumex, Hungary, has been reactivated.

The products MLH 215 Marlboro 100s, MPH 215 Multifilter 100s, MLK 215 Marlboro KS, and MER 215 Merit, manufactured under contract for PMH and PMG, have been withdrawn.

Modified packing specs for brands sold on the Swiss market have been distributed: The "Warning..." text has to be larger in size and is repositioned, on some of the brands.

1.2 Intertaba S.p.A. Zola Predosa/Bologna

New filter making specs have been prepared for a 120 mm Marlboro filter, for sale to the Ivory Coast, and for a 120 mm porous combined (Ambassador) filter, for sale to ATO Finland, for their re-engineered BEM Belmont Multifilter.

1.3 PMH Eindhoven and Bergen op Zoom

Cigarette paper Wattens WP 60 (ex FTR's contract manufacture) is temporarily used on the MLFs Marlboros. PMH's normal paper quality for Marlboros is Mauduit 110-6.

Packing product versions MLF 107 Marlboro Filter and MLK 155 Marlboro King Size, both for sale in Danemark, have been replaced by MLB 050, a Marlboro King Size cigarette packed in a hinge lid pack.

1.4 PMG Munich and Berlin

Project specs for filter and cigarette making have been prepared for the intention of PMG Munich, for project Hilton 100 ref. 301.

New specs for cigarette making (MPH 09) and packing (MPH 210) for Multifilter 100s, standard export version, have been established.

A new packing spec for MLN 041 Marlboro Menthol, 3-cigarette sample, has been established.

New specs for special sales have been prepared for ONF 040 Oncy, ROA 040 Rockwell, WTT 040 Westcoast, and CRF 040 Checker.

1.5 Weltab Bruxelles

The Merit and Marlboro cigarette making specs have been adapted.

New is packing spec MER 059, for a Merit in hinge lid pack to be sold in Luxemburg.

Many updatings are pending for the manufacturing specs valid in WELTAB as well as at Jubilé, Liège, producing for WELTAB.

3. PME STANDARD RECIPES

- 3.1 The individual ingredients for "super juice" flavours have been replaced by the semi-manufactured product supplied by PMI (recipes MERA-AC, MAB-AC, and BSD-AC).
- 3.2 Several recipes have been adapted due to the preparation of certain solutions by Jubilé, Liège BE, on behalf of their WELTAB production.
- 3.3 A new recipe MF-ET-PC has been prepared for the Marlboro solution applied to expanded flue cured tobacco.

4. SPECIFICATIONS ON EDP

About 4½ working days were spent with MM. C. Cotting, EDP, and E. Grossen, QC FTR, to define the functions, tools, and information requirements on the level of the production center.

A preliminary small programme is foreseen for the computer calculation of the cigarette making specs (dimensions, weights, and AccuRay limits).

5. PROCESS ASSURANCE

5.1 AccuRay

After two months of the running industrial trial, the situation is as follows:

FTR and PMG Munich:
No problems.

PMH:
The test is not made and PMH work with the 1980 specs.
Reson: During the various trials, they have found a less good compressibility. PMH is now studying the relation between tobacco weight and compressibility.

WELTAB:
MER Merit They work at - 2,5 %.
MLF Marlboro They have worked at - 2,0 % almost the whole month. They had to modify this limit towards the end of the month due to some problems with loose ends.

5.10 New Primary Bergen oZ and Berlin (References 1 and 2)

Following the problems encountered in FTR with the pneu-

1.6 PMUK London

A new packing version has been prepared for the sale of 16s vend machine Marlboros, manufactured by Manchester Tobacco Company.

1.7 PM Nigeria, Ilorin

1.8 Licensees

- Holland:
Following the re-engineering of the L & M brands manufactured by Ed. Laurens BV The Hague (and Bruxelles), to bring down the smoking numbers, the complete specification files for processing, filter and cigarette making have been reviewed and some of the packing specs have been modified.
- Poland:
The complete specs file has been reviewed.
- Greece:
The Marlboro King Size, ex Papastratos, is now manufactured with a 20 mm filter. The filter and cigarette making specs have been modified.
Contacts have also been established by the Area Operation Manager, regarding the Greek projects (manufacture of three new brands, amongst others an Ambassador).
- DDR:
New cigarette making specs (MPH 10) and packing specs (MPH 301) have been prepared for the Nordhausen factory which is supposed to produce this brand for standard export.
- Finland:
Modified, provisional specs have been prepared for a re-engineered Belmont Multifilter BEM. It will be equipped with a porous 120 mm charcoal filter. Hauni needle dilution and a dilution of 24 % (US) are foreseen.
- Hungary:
Preliminary contacts with AOD regarding the possible manufacture of a Multifilter King Size (soft) and two 100 mm (Eve, Lark) cigarettes.

2. MATERIAL SPECIFICATIONS

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matic transport of dry stems (12-13 %), an information has been passed to the two production centers so that they should be aware of the problem.

5.13 MTI Lecce, Production of Diana (Reference 3)

The final report has been distributed.

5.14 ETNA

A model specification for flue cured tobacco, matching FTR's spec, has been send to PMG and PMH for information.

5.15 Quality Workshop (Reference 4)

The report on the PME meeting of February 17, 1981, has been distributed.

Graphs:

- Comparison between the production centers (monthly averages) for 16 main defect chosen according to the PME Finished Product report.
- Comparison between brands manufactured at the same production center, for 15 main defects (monthly averages). This has been made for PMG Munich, PMH Bergen oZ and WELTAB.

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References

1. Stem line in new primary in Bergen OZ. Memo T. Bel to J. Peterse 20.2.1981
2. Stem line new primary in Berlin. Memo T. Bel to W. Hilmer 20.2.1981
3. Report on visit to Lecce. Memo T. Bel/F. Käser to A. Trento 20.2.1981
4. Quality Workshop. Minutes T. Bel to participants 23.2.1981